



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

647.7712
Job Sheet 170486



Part No: 647.7712

Job Qty: 16 ea

Part Name: Strut Tube



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/16/18

Job Tracking No:

Due Date: 1/24/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV A2 IPP REV:A NEW ISSUE 12-11-06 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	16 Ea		1/24/18	0.00	0.00	Start Up Machining-1		DAS
100	Hardinge	16 pcs		1/24/18	0.00	1.52	Hardinge		23
110	QC	16 pcs		1/24/18	0.00	0.00	QC2 Machining-1		9-89
120	QC	16 pcs		1/24/18	0.00	0.00	QC8 Machining-1		OK 18/01/20
130	Packaging	16 pcs		1/24/18	0.00	0.00	Packaging3-1 WA 001		AT 18/01/20
140	QC21-SA	16 Ea		1/24/18	0.00	0.00	QC21		

Part Op
Descriptions: 100 - Machine as per folio FB148 FOLIO REV: _____ Deburr

DAS
21
9-89

JAN 22 2016

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M4130NR0.375	1	37	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Strut Tube	0.580inches $\pm$ 0.030	0.610 0.550		
2	Strut Tube	0.375inches $\pm$ 0.010	0.385 0.365	Diameter	
3	Strut Tube	0.225inches + 0.005 - 0.001	0.230 0.224	Diameter	

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DQA: _____ Date: _____

WORK ORDER NON CONFORMANCE / UPDATE



QA

W

Da

DART
AEROSPACE
S033625



Strut Tube

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Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Work Order update only ☐

AGAINST DEPARTMENT/PROCESS

Cross tube	☐	Water Jet	☐	Engineering	☐
Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐
Finishing	☐	Rec/Store/Packaging	☐	Other	☐
Composite	☐	Supplier	☐		

MRB (QSI042) Approval

Disposition

Completed By

Lead hand / Supervisor
Approval Verification

QC / QA Coordinator
Approval

PART NO: 647.7712
Original Serial #: S033625
Revision:
Operation: Start up Operation
Change No:

01/18/18
Job No: 170486

Root Cause

Environment	☐	No Re-verification	☐
Design	☐	Operator	☐
Doc/Data	☐	Offset/Setup	☐
Equip/Tooling	☐	Supplier	☐
Handling/Pre	☐	Training	☐
Material	☐	Use for Testing	☐
Internal Transport	☐	Poor Information	☐
Tribal Knowledge	☐	Rushing	☐
LOA	☐	Product Improvement	☐
Substation	☐	Process Improvement	☐
Past Expiry Date	☐	Manufacturing Process	☐
Misidentified	☐	Past Due	☐

FAULT CATEGORY

Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐

OTHER :



Dart Hawkesbury
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Tel (613) 632-5200

Inventory

Operation Number	Operation	Serial Number	Job	Quantity	Weight	Original Serial Number	Location	Container	Status	Added	Special Comments	Label	Supplier	Change No
Part Number: 647.7712 Revision: Strut Tube														
140	QC21-SA	S033625	170486	16 Ea	0	S033625	WA001	Bin	Stock	1/18/2018	Issue Container			
Operation Totals:		1		16	0									
Part Totals:		1		16	0									
Part Number: M4130NR0.375 Revision: 4130 Steel Round Bar .375"														
100	Receive Ft	S033623	170486	0 ft	0		MAT032		WIP	1/18/2018	Issue Container			
Operation Totals:		1		0	0									
Part Totals:		1		0	0									
Totals:		2		16	0									

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					